

Date: Friday, 6/1/2007 1:02:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 32746	
Estimate Number : 12722	
P.O. Number : <i>N/A</i>	Part Number : D353615
This Issue : 6/1/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 31994	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/8/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.06.01	
Comment : Est Rev: A New Issue 07-02-14 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 1.0340 sf(s)/Unit Total : 20.6808 sf(s)

NEOPRENE SHEET 0.063

Batch: *m103104**ml 07 06 03**(20)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: *A*Prog Rev: *A**ml 07 06 03**(20)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*ml 07 06 04**(20)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SA 07.06.04**(20)*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*[Signature] 07/06/04 (20)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/06/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32746

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



28

Comment: FINAL INSPECTION/W/O RELEASE

207/06/05

Job Completion



207/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32746
<b>Description:</b> Gasket		<b>Part Number:</b>	D3536-15
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	✓		m.t	
35.65	+/-0.030	35.65	✓		m.T	
33.65	+/-0.030	33.65	✓		m.T	
30.15	+/-0.030	30.15	✓		m.T	
24.90	+/-0.030	24.90	✓		m.T	
19.65	+/-0.030	19.65	✓		m.t	
14.40	+/-0.030	14.40	✓		m.T	
9.15	+/-0.030	9.15	✓		m.T	
5.65	+/-0.030	5.64	✓		<del>m.T</del> VLN	
3.90	+/-0.030	3.89	✓		VLN	
8.00	+/-0.030	8.00	✓		m.t	
16.00	+/-0.030	16.00	✓		m.T	
24.00	+/-0.030	24.00	✓		m.T	
0.30	+/-0.030	0.300	✓		VLN	
0.30	+/-0.030	0.300	✓		VLN	
1.89	+/-0.030	1.88	✓		VLN	
Ø0.19	+0.005/-0.001	0.19	✓		VLN	

<b>Measured by:</b>	MLM	<b>Audited by:</b>	SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07.06.04	<b>Date:</b>	07.06.04	<b>Date:</b>	N/A

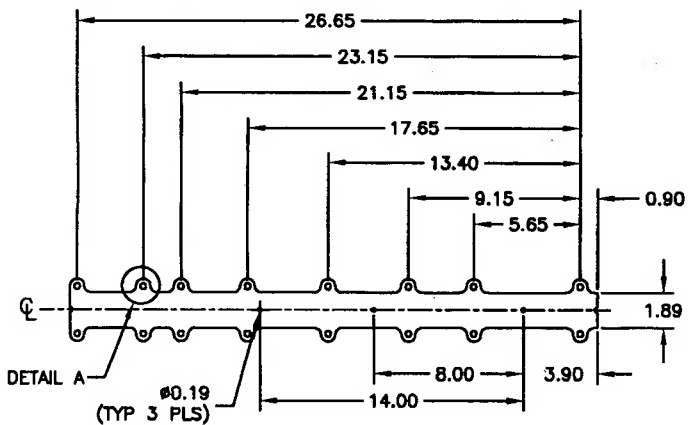
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	SA

**DART**

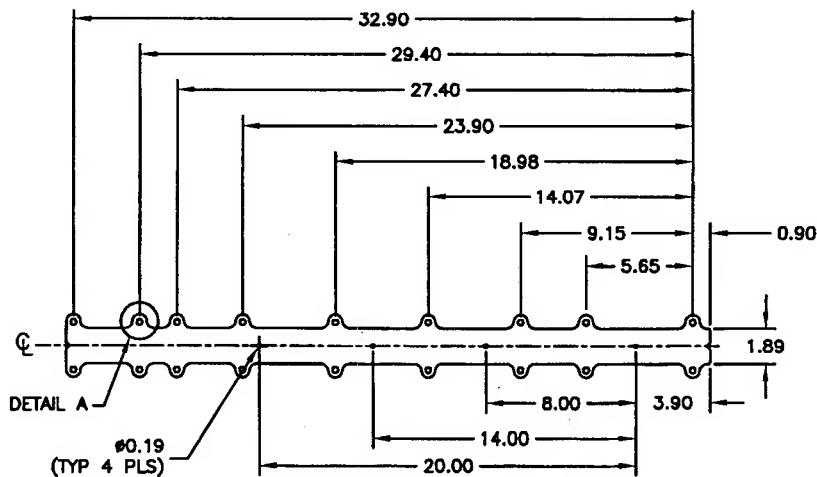
RELEASED

09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

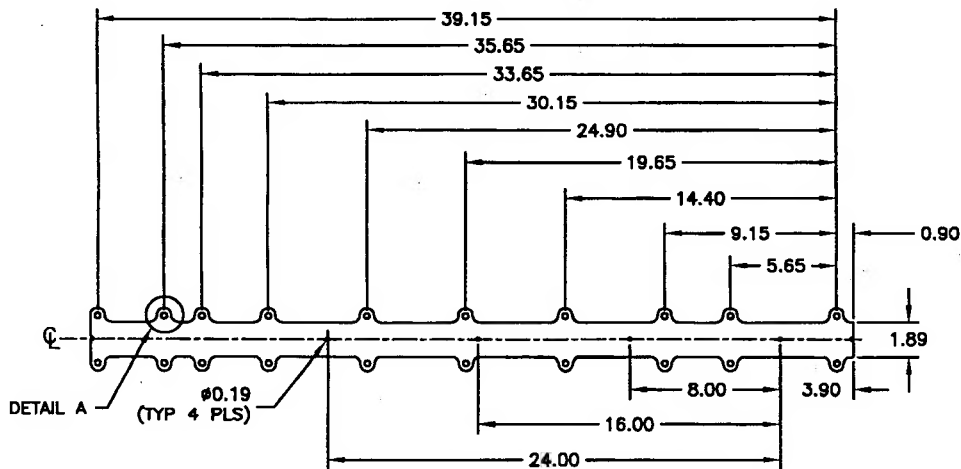
SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32746

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

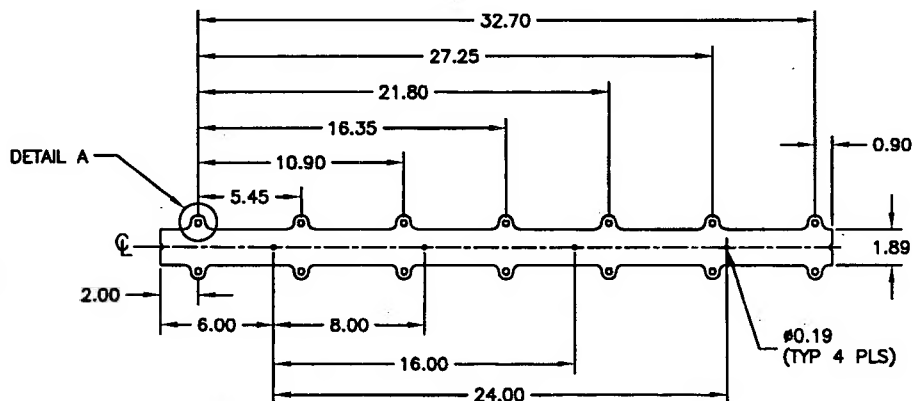
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 2 OF 6
	SCALE <b>1:10</b>	

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07.02.12



**D3536-15 GASKET**



**D3536-21 GASKET**

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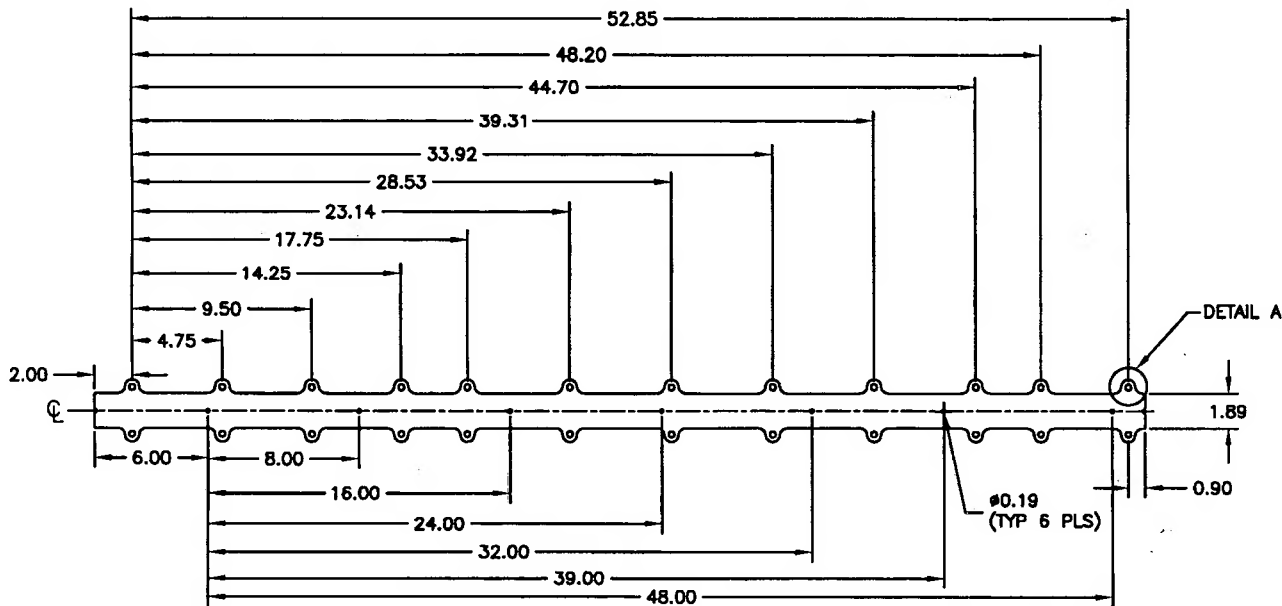
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

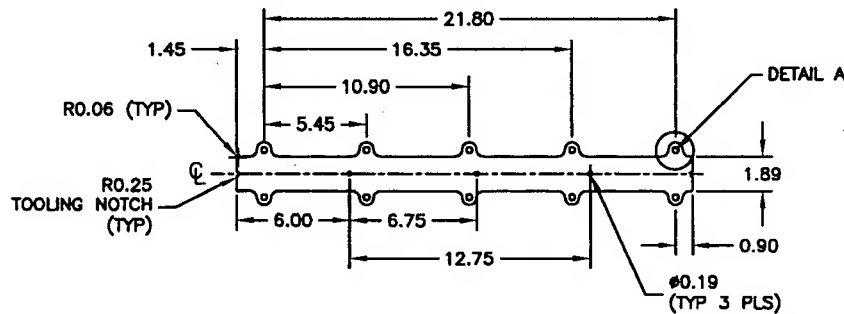
**DART**

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
				SCALE 1:10

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07/02/12



**D3536-23 GASKET**



**D3536-25 GASKET**

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WITHOUT NOTICE  
WORK ORDER  
NO 21140

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

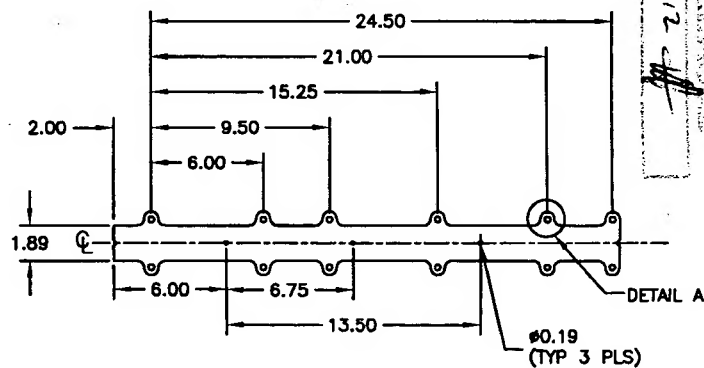


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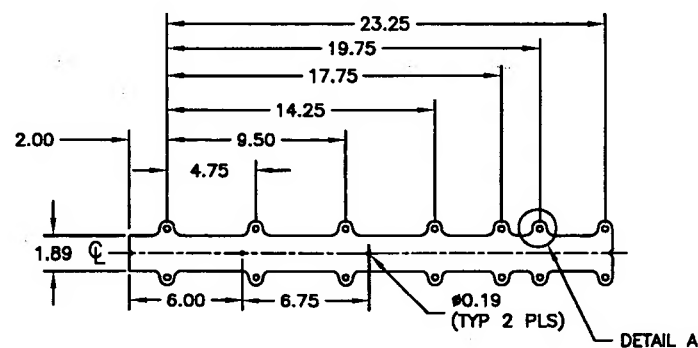
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

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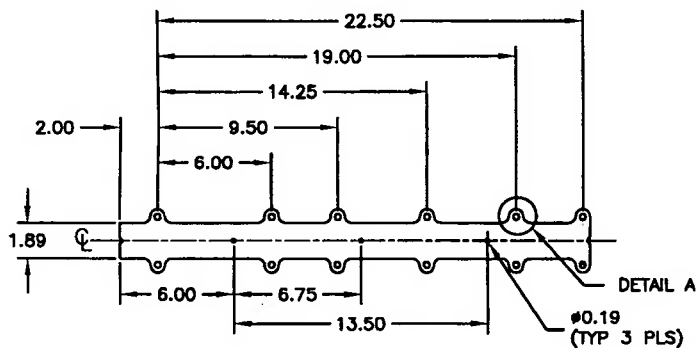
07.02.12



**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

**NOTES**

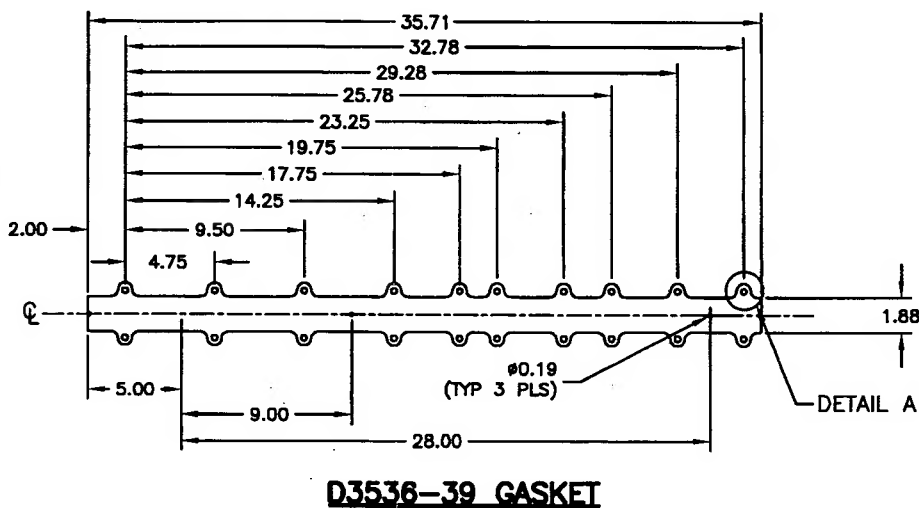
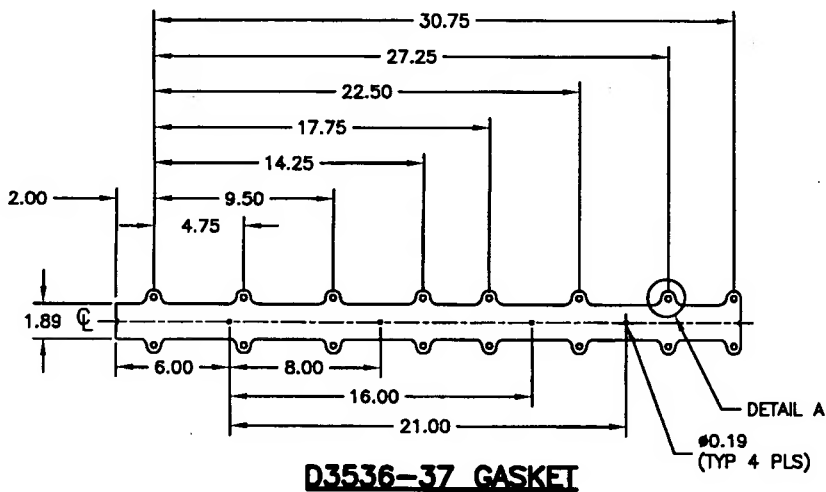
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WORK ORDER

**DART**

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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>		TITLE <b>GASKET</b>	SHEET 5 OF 6
			SCALE <b>1:10</b>

07.02.12 **PH**



**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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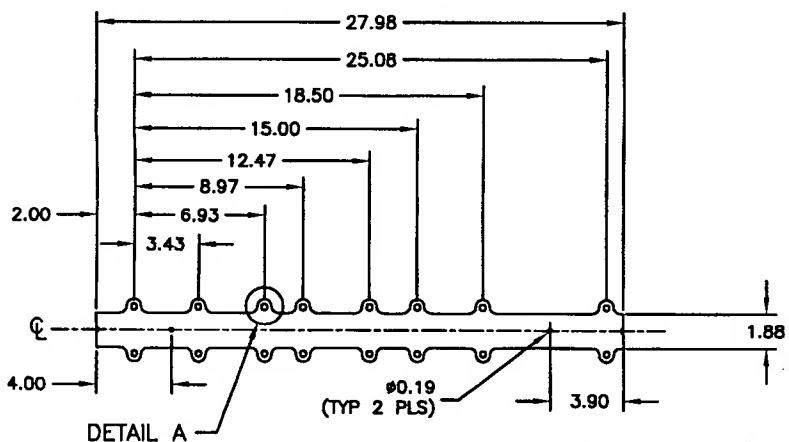
WORK ORDER

NO. **32746**

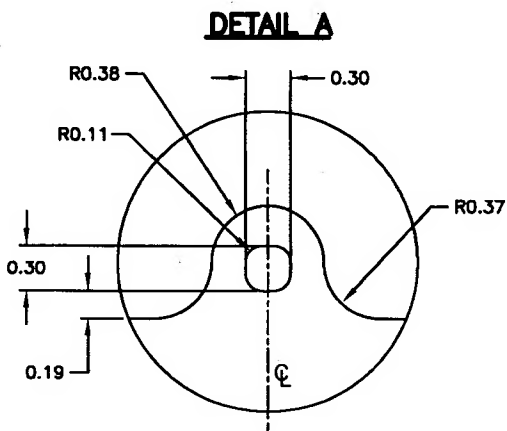
**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	REV. A
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	SHEET 6 OF 6
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SCALE <b>1:10</b>	

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07.01.22



**D3536-41 GASKET**



**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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